

# Work Order ID 121315

Wednesday, July 30, 2014 4:24:29 PM

**\*121315\***

Page 1

Item ID: D4464-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fuel Tank Assembly

Start Date: 6/24/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 6/24/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: [Signature] Date: 14-7-30

Tooling:

Date:

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4464	F

100 Weld per dwg A/R Aluminum rod Batch: 12838 0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

QC9- D4023-3 cap as per dwg D4464

110

**\*110\***

QC

Quality Control

Memo

QC9- Inspect visual per QSI004- Fusion W

Remove o pino de segurança antes de montar  
 Atention,  
 remove safety pin before installation  
 Achtung!  
 Vor Einbau Sicherungssstift herausnehmen

1 0 14-07-30

1 14-7-30

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

Work Order ID 121315

June-24-14 8:57:03 AM

\*121315\*

Page 2

Item ID: D4464-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Fuel Tank Assembly

Stop \*NS2\*

Start Date: 6/24/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 6/24/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
112		0.00							
<b>*112*</b>									
Small Fab									
Small Fab	Memo	0.00							
	1- Install hinge wet with proseal as per dwg								
	A/R Proseal Batch: <u>A128638</u>								
	2- Wet install baffles to front and back panel using rivet and Proseal as per dwg								
	A/R Proseal Batch: <u>M128638</u>								
114	QC5- Inspect part completeness to step on W/O	0.00							
<b>*114*</b>									
QC									
Quality Control	Memo	0.00							

DAS  
36  
9-89

14/07/30

D

B 14-10-9

# Work Order ID 121315

June-24-14 8:57:03 AM

**\*121315\***

Page 3

Item ID: D4464-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fuel Tank Assembly  
 Start Date: 6/24/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 6/24/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Weld per dwg A/R Aluminum rod Batch: _____	0.00							
<b>*120*</b>		<i>4129399</i>							
Large Fab		<i>4128956</i>							
Large Fab	Memo	0.00							
	1- Weld D4001-1 and D4000-5 onto D4463-1 Top								
	2- Weld D3999-041/-043 doubler, ensure doubler and angle holes line-up for D4000-047								
	Transfer drill and c/sink D4975-1 bracket to bottom bracket , wet install as per dwg								
	Proseal Batch: <i>M128638</i>				<i>1x</i>		<i>14/10/09</i>	DAS 36 9-89	
	3- Weld D4000-043 and D4000-045 on tank as per dwg.								
	4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 and wet install with rivets as per dwg								
	Proseal Batch: <i>M128638</i>				<i>1x</i>		<i>14/10/09</i>	DAS 36 9-89	
	5-Weld D4463-7 fwd end								
	***PURGE INSIDE OF TANK***								
	6-Weld top D4463-1 using DT9811 and DT9810								
	***PURGE INSIDE OF TANK***				<i>1x</i>			DAS 43 9-89	

NOV 05 2014

*PTO*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 8/09/11 Date: 14/12/22Work Order update only ☐

Work Order: <u>121315</u>	<b>DISPOSITION</b> Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D4464-041</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input checked="" type="checkbox"/>
NCR No. <u>144511</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design <input checked="" type="checkbox"/>	14-11-13		①	D4000-045 will not screw in. Design problem D4000-1	SEE Attached Last Prov 14/12/15	install angled shim to orient D4000-1 at 2.8° (6061-T6 R#101644)	DAS 36 9-89 14/11/17	DAS 38 9-89 NOV 27 2014	see we in Back for screws & rivets?	
Doc/Data <input type="checkbox"/>										
Equip/Tooling <input type="checkbox"/>										
Handling/Pre <input type="checkbox"/>										
Material <input type="checkbox"/>										
Operator <input type="checkbox"/>										
Offset/Setup <input type="checkbox"/>										
Process <input type="checkbox"/>										
Supplier <input type="checkbox"/>										
Training <input type="checkbox"/>										
Transport <input type="checkbox"/>										
Unapproved <input type="checkbox"/>										

## FAULT CATEGORY

NOV 27 2014

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input checked="" type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

Work Order ID 121315

June-24-14 8:57:03 AM

\*121315\*

Page 4

Item ID: D4464-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fuel Tank Assembly  
 Start Date: 6/24/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 6/24/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123 *123* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo ***Pressure Test as per dwg D4464***	0.00  0.00				1		NOV 20 2014	DAS 24 9-89
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				1		NOV 20 2014	DAS 24 9-89
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo 1- brush alodine on tank. No alodine inside	0.00  0.00				1		<del>NOV 20 2014</del> PTO 125	

1x d  
 [Signature]  
~~NOV 20 2014~~  
 PTO 125  
 →

DQA: . Date: \_\_\_\_\_



# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: SD Date: 14/12/22Work Order update only ☐

Work Order: <u>121315</u>  Part No. <u>124464-011</u>  NCR No. <u>14-4512</u>	<b>DISPOSITION</b>  Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input checked="" type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input checked="" type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input checked="" type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>	14.11.24	150	①	alodine was too dark in some place + some spot didn't have any alodine at all.  R.C. operator was alodining part for the first time. Employee will be trained	14/11/23 Q22042	scuff tank and re-alodine	14/11/23 21	DAS 9 9-89  14.11.25	DAS 38 9-89  NOV 27 2014
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input checked="" type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input checked="" type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input checked="" type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

# Work Order ID 121315

June-24-14 8:57:03 AM

**\*121315\***

Page 5

Item ID: D4464-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fuel Tank Assembly  
 Start Date: 6/24/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 6/24/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160	QC7-Inspect Chemical Conversion Coat	0.00							DAS 9 9-89
<b>*160*</b>							14-11-25		
QC	Memo	0.00							
Quality Control									

164		0.00							DAS 36 9-89
<b>*164*</b>									
Small Fab	Memo	0.00							
Small Fab	1- Wipe with clean cloth and wash and wipe								
	2- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890								
	A/R Proseal 890 Batch: <u>M130090</u>								

166	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
<b>*166*</b>									
QC	Memo	0.00							
Quality Control									

NOV 26 2014



# Work Order ID 121315

June-24-14 8:57:03 AM

**\*121315\***

Page 6

Item ID: D4464-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fuel Tank Assembly  
 Start Date: 6/24/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 6/24/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							DAS 41 9-89
<b>*170*</b>						1			
SprayPaint	Memo	0.00							
Spray Painting	***MASK PROIOR PRIME AND PAINT***								14-11-26
	PRIME TEMPO GREY AS PER DWG AND QSI								
	PRIMER BATCH: <u>128927</u>								
	<sup>matte</sup> PAINT GREY AS PER DWG AND QSI								
	PAINT BATCH: <u>127810</u>								
180	QC14- Inspect Spray Paint	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

D 14-11-27 PD

# Work Order ID 121315

June-24-14 8:57:03 AM

**\*121315\***

Page 7

Item ID: D4464-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fuel Tank Assembly  
 Start Date: 6/24/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 6/24/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
<b>*190*</b>									
Small Fab	Memo	0.00							
Small Fab	1- Mask off area, where access cover is applied								
	2- Abrade surface with red scotch brite								
	3- Assemble as per dwg								
	4- Install cushion using contact cement A/R Contact Cement Batch: <u>1300L</u> <b>M128871</b>								
200	QC5- Inspect part completeness to step on W/O	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
38  
9-89  
NOV 27 2014

June-24-14 8:57:03 AM

**\*121315\***

Page 8

**Accept**

**\*N900040100\***

**Setup Start \*NS1\***

Stop \*NS2\*

**Item Name:** Fuel Tank Assembly

**Start Date:** 6/24/14      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 6/24/14      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

## Operation Description

### Set Up/ Run Hours

**Tool ID****Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
Qty

### Reject Number

## Insp. Stamp

210

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*210\***

### Packaging

## Memo

0.00

## Packaging

DAS  
06  
9-59

NOV 27 2014

220

QC21- Final Inspection - Work Order Release

0.00

\*220\*

QC

## Memo

0.00

## Quality Control

MCJ 14-11-28

MF  
14-11-27

## June-24-14 8:57:06 AM

**Work Order ID:** 121315

**\*121315\***

- Parent Item: D4464-041

**\*D4464-041\***

**Parent Item Name:** Fuel Tank Assembly

**Start Date:** 6/24/14**Required Date:** 6/24/14

**Start Qty: 1.00**

**Required Qty: 1.00**

**Comments:** IPP REV:A 11.11.23 NEW ISSUE DD VRF:EC IPP REV:B  
12.03.08 AS PER DWG REV.B DD VRF:EC IPP REV:C 12.04.24  
ECN 12-571 DD VRF:EC IPP REV:D 13.10.30 DWG  
REV PE1 DD VRF:JLM IPP REV:E 14.06.13 AS PER DWG  
REV.E DD VRF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-5		Manufactured	No			190	Each	63.0000	2	2		14/11/27	DAS 36 9-89
<b>*D3997-5*</b> Placard													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST244A			63						
				72611			63						
D3997-11		Manufactured	No			190	Each	24.0000	1	1		14/11/27	DAS 36 9-89
<b>*D3997-11*</b> Placard													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST244A			24						
				106884			12						
				107679			9						
				99791			3						
D3997-17		Manufactured	No			190	Each	21.0000	1	1		14/11/27	DAS 36 9-89
<b>*D3997-17*</b> Placard													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST244A			21						
				100181			5						
				106785			7						
				107632			9						

# Picklist Print

June-24-14 8:57:06 AM

Page 2

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D3997-29  
**\*D3997-29\***  
Placard

Manufactured No

190 Each

13.0000

1 1

\*\*

DAS  
36  
9-89

14/11/27

Location

Loc Qty

Loc Code

ST244A

13

100182

2

106864

11

D3997-43  
**\*D3997-43\***  
Placard

Manufactured No

190 Each

24.0000

1 1

\*\*

DAS  
36  
9-89

14/11/27

Location

Loc Qty

Loc Code

ST244A

24

100183

4

106642

10

107558

9

82960

1

D3999-7  
**\*D3999-7\***  
Corner

Manufactured No

120 Each

17.0000

1 1

\*\*

14/14/08

Location

Loc Qty

Loc Code

WA003

17

108621

17

Manufactured No

120 Each

5.0000

1 1

\*\*

DAS  
36  
9-89

14/10/09

Location

Loc Qty

Loc Code

prelim

5

120690

5

D4000-1  
**\*D4000-1\***  
Fuel Supply Fitting

B123029  
(K)

June-24-14 8:57:06 AM

Shop Packet Print

Page 2

# Picklist Print

June-24-14 8:57:06 AM

Page 3

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D4000-5 Manufactured No

120 Each 18.0000 1 1

**\*D4000-5\***

Fuel Tank Vent Fitting

\*\*

DAS

43

9-89

NOV 04 2014

Location

Loc Qty

Loc Code

WA003

18

100528

3

106917

9

107388

6

D4000-9 Manufactured No

120 Each 54.0000 3 3

**\*D4000-9\***

Grommet

\*\*

Location

Loc Qty

Loc Code

WA003

54

105466

16

106808

38

D4000-045 Manufactured No

120 Each 8.0000 1 1

**\*D4000-045\***

Fuel Pickup Fitting Assembly

\*\*

DAS

43

9-89

NOV 05 2014

Location

Loc Qty

Loc Code

WA003

8

106873

2

107357

4

111048

2

D4008-11 Manufactured No

120 Each 0.0000 1 1

**\*D4008-11\***

Hinge Half

\*\*

DAS

36

9-89

June-24-14 8:57:06 AM

Shop Packet Print

Page 3

# Picklist Print

June-24-14 8:57:06 AM

Page 4

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

~~D4008-041~~  
**\*D4008-041\***  
Fuel Filler Splash Guard Assembly

Manufactured No

190 Each 13.0000 1 1

\*\*

14/11/27 <sup>DAS</sup> 36 9-89

Location

Loc Qty

Loc Code

ST108

7

107372

7

ST242A

6

106901

6

Each

7.0000

1

\*\*

D4023-1

Manufactured No

**\*D4023-1\***  
Cap And Flange

Location

Loc Qty

Loc Code

Mezz

7

64879

6

66862

1

Each

19.0000

1

1

\*\*

D4023-3

Manufactured No

**\*D4023-3\***  
Cap And Flange

Location

Loc Qty

Loc Code

ST143

14

106700

10

107201

2

84422

2

WA003

5

120208

5

June-24-14 8:57:06 AM

Shop Packet Print

Page 4

# Picklist Print

June-24-14 8:57:06 AM

Page 5

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

**\*D4025-5\***  
Fuel Quantity Sender

Manufactured No

190 Each 15.0000 1 1

\*\*

68-6  
93  
DAS  
11/11/27

Location

Loc Qty

Loc Code

ST140

15

106832

10

107655

5

D4057-1

Manufactured No

120 Each 94.0000 3 3

\*\*

11/14-08-08

**\*D4057-1\***  
Retaining Ring

Location

Loc Qty

Loc Code

WA003

94

106766

47

107269

47

D4062-041

Manufactured No

190 Each 12.0000 1 1

\*\*

DAS  
43  
9-89  
NOV 05 2014

**\*D4062-041\***  
Tank Support Assembly

Location

Loc Qty

Loc Code

WA003

12

100076

2

106669

1

107170

5

90627

4

D4124-1

Manufactured No

120 Each 32.0000 4 4

\*\*

DAS  
43  
9-89  
NOV 04 2014

**\*D4124-1\***  
Tab

Location

Loc Qty

Loc Code

WA003

32

100079

7

106845

5

107333

20

B107170 → 1x

B107333 → 4x

June-24-14 8:57:06 AM

Shop Packet Print

Page 5



# Picklist Print

June-24-14 8:57:06 AM

Page 6

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D4125-1

Manufactured No

120

Each

10.0000

1

1

**\*D4125-1\***

Sump

\*\*

14.07.25

Location

Loc Qty

Loc Code

WA003

10

106764

3

107267

2

110961

3

99890

2

D4125-3

Manufactured No

120

Each

13.0000

1

1

**\*D4125-3\***

End

\*\*

14.07.25

Location

Loc Qty

Loc Code

WA003

13

106826

3

111009

3

114307

5

99891

2

D4404-5

Manufactured No

120

Each

7.0000

2

**\*D4404-5\***

Cushion, Fwd

\*\*

14/11/27 DAS 36 9-89

Location

Loc Qty

Loc Code

ST145

7

102143

6

99743

1

D4462-1

Manufactured No

112

Each

6.0000

1

1

**\*D4462-1\***

Baffle

\*\*

14/07/30 DAS 36 9-89

Location

Loc Qty

Loc Code

WA

6

121109

6

June-24-14 8:57:06 AM

Shop Packet Print

Page 6

# Picklist Print

June-24-14 8:57:07 AM

Page 7

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D4462-3

Manufactured No

112

Each

6.0000

1

1

\*\*

DAS  
36  
9-89

**\*D4462-3\***

Baffle

Location

Loc Qty

Loc Code

WA

6

121158

6

D4463-041

Manufactured No

120

Each

4.0000

1

1

\*\*

DAS  
43  
9-89

NOV 04 2014

**\*D4463-041\***

Tank Top Assembly

Location

Loc Qty

Loc Code

WA003

4

120921

4

D4463-3

Manufactured No

120

Each

4.0000

1

1

\*\*

**\*D4463-3\***

Tank Aft End

Location

Loc Qty

Loc Code

WA003

4

120922

4

D4463-5

Manufactured No

120

Each

5.0000

1

1

\*\*

**\*D4463-5\***

Tank Upper Cut Out

Location

Loc Qty

Loc Code

WA003

5

120923

5

D4463-7

Manufactured No

120

Each

0.0000

1

1

\*\*

DAS  
43  
9-89

NOV 04 2014

**\*D4463-7\***

Tank Fwd End

June-24-14 8:57:07 AM

Shop Packet Print

Page 7

# Picklist Print

June-24-14 8:57:07 AM

Page 8

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D4463-9

Manufactured No

112

Each

4.0000

1

1

**\*D4463-9\***

Tank Back

\*\*

*14.07.28*

Location

Loc Qty

Loc Code

WA 121175  
120925

4

4

1

D4463-11

Manufactured No

112

Each

6.0000

1

1

**\*D4463-11\***

Tank Front

\*\*

*14.07.15*

Location

Loc Qty

Loc Code

WA003  
121168

6

6

1

D4463-13

Manufactured No

190

Each

5.0000

1

1

**\*D4463-13\***

Tank Bottom

\*\*

*14.07.24*

Location

Loc Qty

Loc Code

WA003 B121165 = 1 5  
111589 1  
120926 4

5

1

4

1

D4577-041

Manufactured No

190

Each

20.0000

1

1

**\*D4577-041\***

Fwd Access Panel Assembly

\*\*

*14/11/25* DAS  
36  
9-89

Location

Loc Qty

Loc Code

ST142  
106703

20

20

1

# Picklist Print

June-24-14 8:57:07 AM

Page 9

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

**D4577-1**  
**\*D4577-1\***  
Rear Access Panel

Manufactured No 190 Each 9.0000 1 1

\*\*

DAS  
36  
9-89

Location Loc Qty Loc Code

ST142 9

106923 9

Manufactured No 190 Each 9.0000 1 1

\*\*

DAS  
36  
9-89

Location Loc Qty Loc Code

ST142 9

106697 8

107197 1

Manufactured No 190 Each 11.0000 1 1

\*\*

DAS  
36  
9-89

Location Loc Qty Loc Code

ST232A 11

120927 11

Manufactured No Each 11.0000 1

\*\*

DAS  
36  
9-89

Location Loc Qty Loc Code

st128 11

120928 11

**D4968-1**  
**\*D4968-1\***  
Side Cushion

**D4975-1**  
**\*D4975-1\***  
Bracket

June-24-14 8:57:07 AM

Shop Packet Print

Page 9

# Picklist Print

June-24-14 8:57:07 AM

Page 10

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

Each

4,636.000

24

**\*\***

DAS  
36  
9-89

**\*AN3C4A\***

Bolt

14/11/25

~~11/25/07~~

M/30716  
(242)

Location

Loc Qty

Loc Code

FG	20	
122814	20	
Return2014	9	
124221	9	
ST350	2513	
125388	3	
M128606	6	
M128739	4	
M129520	2500	
ST350/513	26	
M128606	26	
ST512	3	
124221	3	
ST513	2065	
M127410	1	
M127832	62	
M128634	28	
M128879	1974	

# Picklist Print

June-24-14 8:57:07 AM

Page 11

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

Each

424.0000

5

**\*AN3-5A\***

Bolt

\*\*

14/11/27

DAS  
36  
9-89

Location

Loc Qty

Loc Code

GA

45

117423

45

ST350

150

m129507

150

ST511

169

m126559

92

m129246

77

ST512

60

124561

60

1125445

(54)

AN3-6A

Purchased

No

190

Each

317.0000

4

4

**\*AN3-6A\***

Bolt

\*\*

14/11/27

68-6  
36  
DAS

Location

Loc Qty

Loc Code

ST351

313

116390

11

M128403

2

M128739

150

M128978

150

ST511

4

M127044

4

4

MS20426AD4-4

Purchased

No

Each

2,913.000

4

**\*MS20426AD4-4\***

Rivet

\*\*

14/10/09

DAS  
36  
9-89

Location

Loc Qty

Loc Code

GA

169

129090

169

ST334

2744

125445

2744

4

June-24-14 8:57:07 AM

Shop Packet Print

Page 11

# Picklist Print

Page 12

June-24-14 8:57:07 AM

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-6

Purchased

No

Each

2,791.000

8

**\*MS20426AD4-6\***

Rivet

\*\*

14/10/09  
DAS  
36  
9-89

Location

Loc Qty

Loc Code

MF4

52

124392

52

ST334

852

124392

852

ST336

1887

M128812

1887

Each

3,583.000

165

\*\*

14/11/27  
DAS  
36  
9-89

Location

Loc Qty

Loc Code

ST312

3583

118614

27

121652

180

M128401

1736

M128754

66

M129499

1574

190

Each

5,662.000

4

4

\*\*

14/11/27  
DAS  
36  
9-89

MS21042L3

Purchased

No

**\*MS21042L3\***

Nut

Location

Loc Qty

Loc Code

ST307

5662

108816

1

123900

955

M126333

55

M127410

13

M127831

41

M128401

48

M128754

4549

4

June-24-14 8:57:07 AM

Shop Packet Print

Page 12

# Picklist Print

June-24-14 8:57:07 AM

Work Order ID: 121315

**\*121315\***

Parent Item: D4464-041

**\*D4464-041\***

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

190

Each

3,032.000

5

5

**\*NAS1149D0332.J\***

Washer

\*\*

14/11/27

DAS  
36  
9-89

Location

Loc Qty

Loc Code

ST276

3032

m128606

253

m128612

2779

M130325 (5x)

NAS1149D0363J

Purchased

No

190

Each

3,382.000

32

32

**\*NAS1149D0363.J\***

Washer

\*\*

14/11/25

DAS  
36  
9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

3359

m126319

6

m128429

3353

32

NAS1149D0316J

M127993

(1x)

14/11/27

DAS  
36  
9-89

\*M520426AD4-8

(5x)

1597962

14/11/27

\*M520426AD4-7

(3x)

M123525

14/11/27



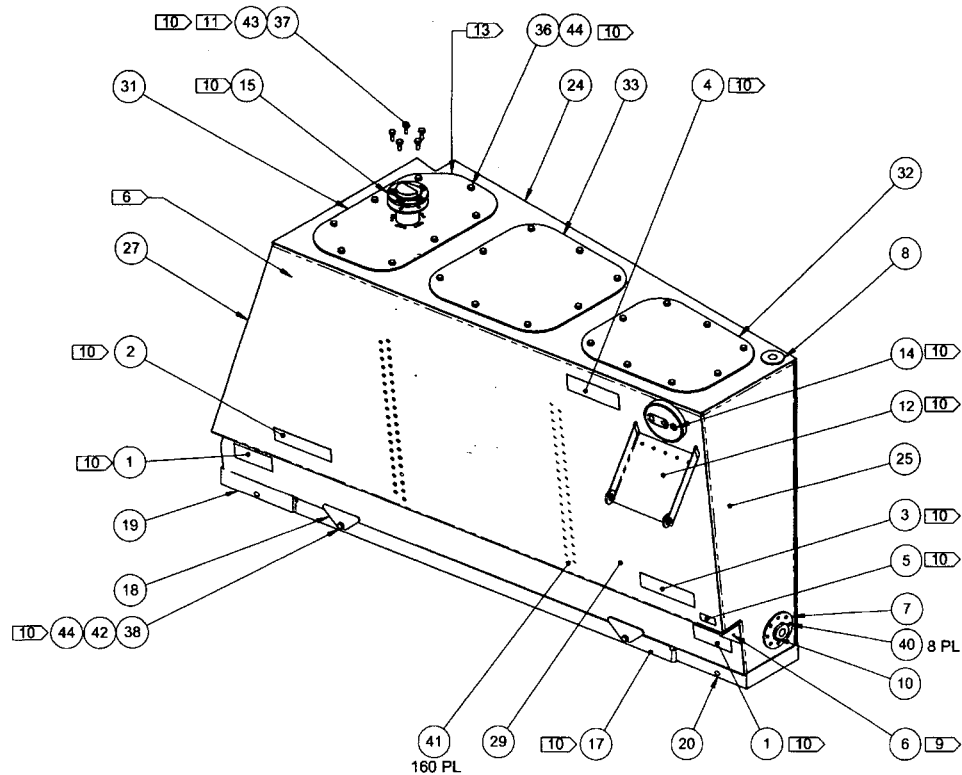
ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4464-041	FUEL TANK ASSEMBLY
1	2	D3997-5	PLACARD (AUX FUEL DRAIN)
2	1	D3997-11	PLACARD (LOADING)
3	1	D3997-17	PLACARD (STOWAGE)
4	1	D3997-29	PLACARD (WARNING)
5	1	D3997-43	PLACARD (EARTH)
6	1	D3999-7	CORNER
7	1	D4000-1	FUEL SUPPLY FITTING
8	1	D4000-5	FUEL TANK VENT FITTING
9	3	D4000-9	GROMMET
10	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
11	1	D4008-11	TANK HINGE HALF
12	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
13	1	D4023-1	FUEL CAP FLANGE
14	1	D4023-3	FUEL CAP
15	1	D4025-5	FUEL SENDER
16	3	D4057-1	RETAINER
17	1	D4062-041	TANK SUPPORT
18	4	D4124-1	TAB
19	1	D4125-1	FWD SEDIMENT BOWL
20	1	D4125-3	AFT SEDIMENT BOWL
21	2	D4404-5	CUSHION, FWD
22	1	D4462-1	BAFFLE
23	1	D4462-3	BAFFLE
24	1	D4463-041	TOP TANK ASSEMBLY
25	1	D4463-3	TANK AFT END
26	1	D4463-5	TANK UPPER CUT OUT
27	1	D4463-7	TANK FORWARD END
28	1	D4463-9	TANK BACK
29	1	D4463-11	TANK FRONT
30	1	D4463-13	TANK BOTTOM
31	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
32	1	D4577-1	REAR ACCESS PANEL
33	1	D4577-3	MIDDLE ACCESS PANEL
34	1	D4968-1	CUSHION, SIDE
35	1	D4975-1	ANGLE BRACKET
36	24	AN3C4A	BOLT
37	5	AN3-5A	BOLT
38	4	AN3-6A	BOLT
39	4	MS20426AD4-4	RIVET, SOLID, CSK
40	8	MS20426AD4-6	RIVET, SOLID, CSK
41	165	MS20470AD4-4	RIVET, SOLID, PAN HEAD
42	4	MS21042L3	NUT
43	5	NAS1149D0332J	WASHER
44	32	NAS1149D0363J	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 121315 MLJ  
140624

**RELEASED**  
2014-06-11  
*sm*

E	UPDATED -041 WITH RE-DESIGNED D4463-3/9-11 AND D4462-1/-3. D4968-1 REPLACES D4404-5 ON TANK SIDE (ZN C3-2) REF NCR 13-3100. AN3-6A REPLACES MS35206-266 (ZN B8-2) NAS1149D0332J REPLACES 5 X NAS1149D0363J (ZN D7-2) REF PAR 12-217 D4975-1 REPLACES D3999-9 (ZN C3-2) REMOVED TAB D3999-11 AND MOVED D3997-43 PLACARD (ZN B6-5) UPDATED BILL OF MATERIALS REVISED ALL NOTES REMOVED SHEET 5	ML	14.05.13
D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS. ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS. REMOVED D4463-13. ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	DD	<b>D4464</b>	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	<b>TANK ASSEMBLY</b>	NTS
DATE	14.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

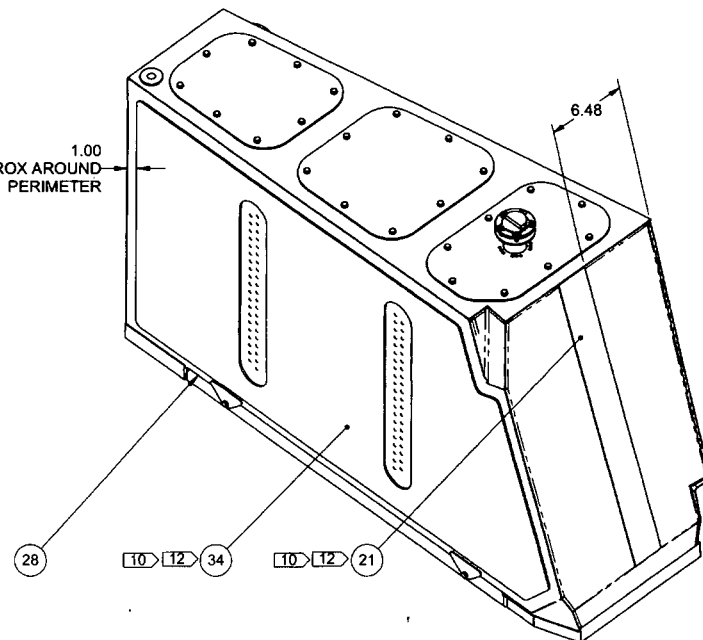


**D4464-041 FUEL TANK ASSEMBLY**

**NOTES:**

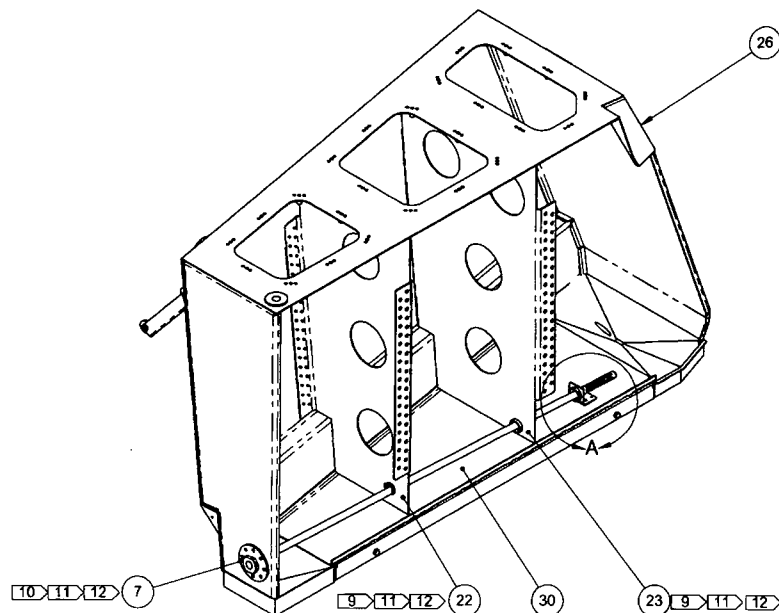
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2  
PAINT GREY (4.2.2.3) PER DART QSI 005 4.22
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
- 7) WEIGHT: 39.21 lbs
- 8) CAP ALL TANK ACCESS POINTS AND PRESSURE TEST TANK PER QSI 038 6.3. VERIFY NO LEAKS
- 9) MASK PRIOR TO FINISH
- 10) INSTALL AFTER FINISH
- 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 12) INSTALL CUSHION USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
- 13) INSTALL D4577-041/-3/-5 ACCESS PANELS WET WITH PROSEAL P/S 890B.

1.00  
APPROX AROUND  
PERIMETER

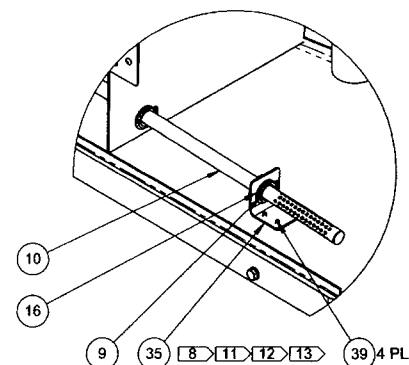


**RELEASED**  
2014-06-11

APPROVED	DESIGN	ML	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	ML		
	CHECKED	AJS	DRAWING NO. <b>D4464</b>	REV. E
	MFG. APPR.	DD	SHEET 2 OF 4	
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	<b>TANK ASSEMBLY</b>	NTS
DATE		14.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D4464-041 FUEL TANK ASSEMBLY**   
D4463-9 TANK BACK REMOVED  
TO SHOW INTERIOR DETAIL



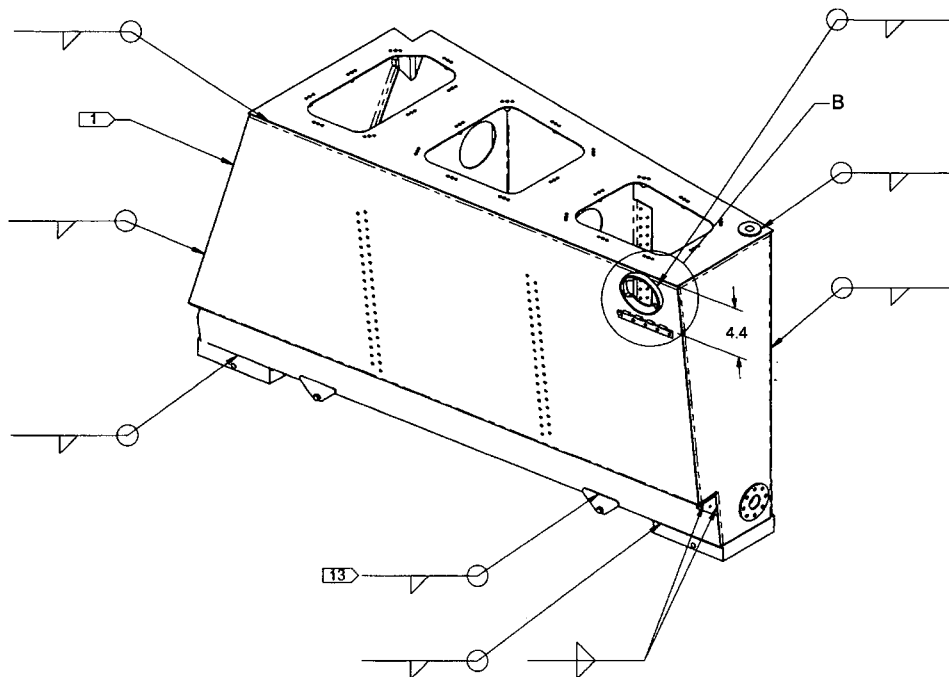
**DETAIL A**  
ROTATED FOR CLARITY  
SCALE 2X

**NOTES:**

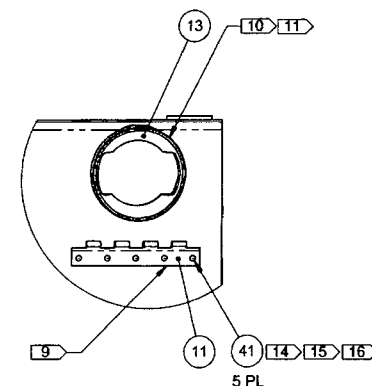
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 39.21 lbs
- 8) COAT FAYING SURFACES OF D4975-1 ANGLE BRACKET AND D4463-13 TANK BOTTOM WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-4 RIVETS
- 9) COAT FAYING SURFACES OF D4462-1/-3 BAFFLES AND D4463-9/-11 TANK FRONT/BACK WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 10) COAT FAYING SURFACES OF D4000-1 FUEL SUPPLY FITTING AND D4463-3 TANK AFT END WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-6 RIVETS
- 11) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF D4975-1 ANGLE BRACKET, D4462-1/-3 BAFFLES AND D4000-1 FUEL SUPPLY FITTING WITH PROSEAL P/S 890B
- 12) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B
- 13) TRANSFER DRILL  $\varnothing 0.128$  HOLES FROM D4975-1 ANGLE BRACKET INTO D4463-13 TANK BOTTOM AND COUNTERSINK HOLES  $\varnothing 0.225 \times 100^\circ$  FROM THE OUTSIDE OF THE TANK

**RELEASED**  
2014-06-11

APPROVED	DESIGN	ML	<b>DART AEROSPACE LTD</b>	
	DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AJS	DRAWING NO.	REV. E
	MFG. APPR.	DD	<b>D4464</b>	SHEET 3 OF 4
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	<b>TANK ASSEMBLY</b>	NTS
	DATE	14.05.13	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D4464-041 FUEL TANK ASSEMBLY**  
WELDING AND RIVETING DETAIL



**DETAIL B**  
ROTATED FOR CLARITY  
SCALE 2X

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 9) CENTER HINGE BELOW FUEL CAP FLANGE
- 10) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 11) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 12) WELD PER DART QSI 004
- 13) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING  
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING
- 14) COAT FAYING SURFACES OF D4008-11 TANK HINGE HALF AND D4463-11 TANK FRONT WITH PROSEAL P/S 890B  
AND WET INSTALL MS20470AD4-4 RIVETS
- 15) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF THE BAFFLES WITH PROSEAL P/S 890B
- 16) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B

**RELEASED**  
2014-06-11

APPROVED	DESIGN	ML	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	ML		
	CHECKED	AJS	DRAWING NO.	REV. E
	MFG. APPR.	DD	<b>D4464</b>	SHEET 4 OF 4
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	<b>TANK ASSEMBLY</b>	NTS
DATE		14.05.13	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

DAI  
AEROSPACE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework <input type="checkbox"/>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
	Scrap <input type="checkbox"/>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design						D4000-1 B123029			
Doc/Data						5MS20470AD 4-8 11960	SA		
Equip/Tooling						3MS20470AD 4-7	14/11/11		
Handling/Pre						1123 525			
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

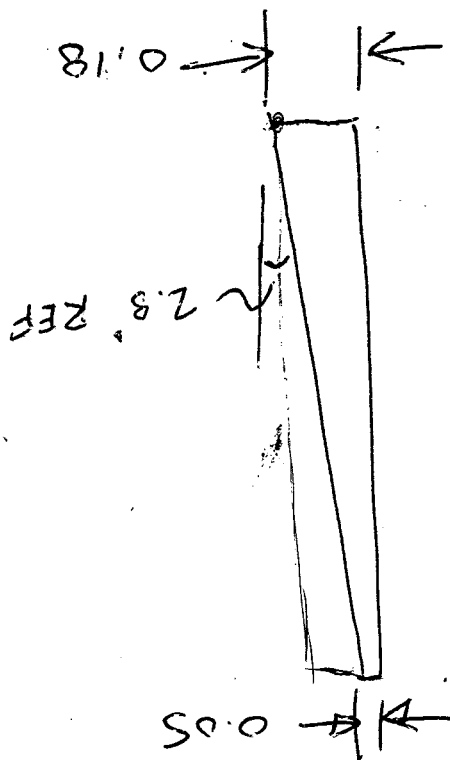
## FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	<input type="checkbox"/> Set-up
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
			<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

9/11/11  
p

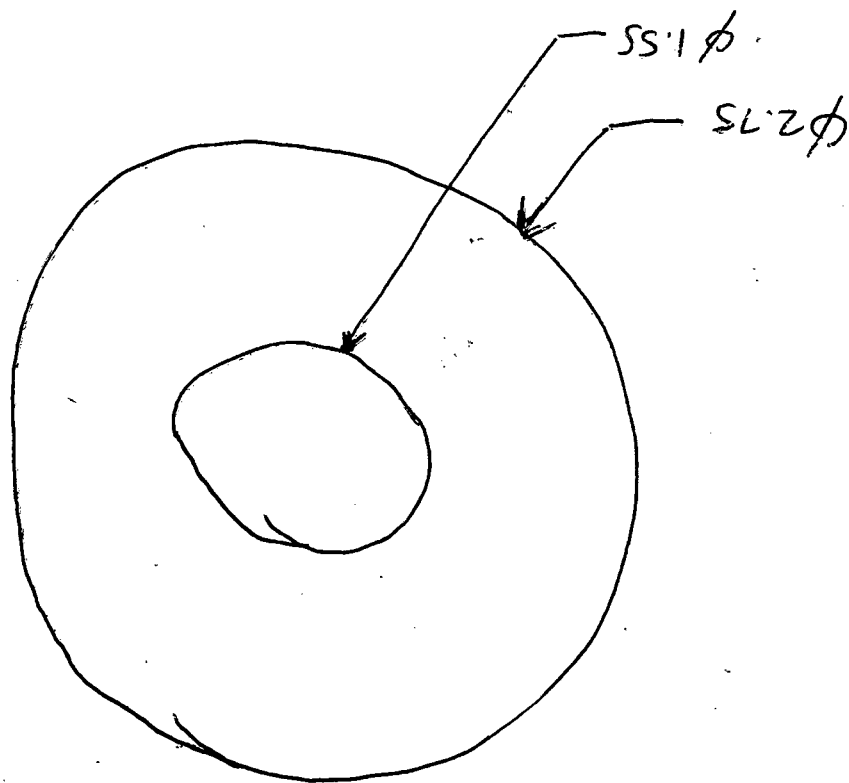
989  
12  
DAS

PL 1



060

6061-T6 ROUND BAR



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: \_\_\_\_\_

Work Order update only ☐

Work Order: <u>121315</u>  Part No. <u>D4464-011</u>  NCR No. _____	<b>DISPOSITION</b>  Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		14/11/12		1	D4000-045 will not screw in. Design problem D4000-1 should be angled to match orientation of D4000-045. One hole in baffle does not align w/ D4000-045 inducing a bend.	DAS 12 9-89  14/11/12	Install angled shim to orient D4000-1 at 2.5° (6061-T6 S/N 101694)			
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport							Remove plastic grommet and open hole in baffle as req'd to clear D4000-045.			
Unapproved							Touch up glodine			
							Ensure tank is fully clean. No chips inside tank.			

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------



Date: 14/12/22

# WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date: 14/12/22

Work Order update only

Work Order: 121315	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. DYK64-K		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. 14-4513		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				<del>will attempt to fit</del>	DAS 12 9-89  14/11/6	Design problem: D4000-1	SL  14-11-10	S  14/11/27	S  14/11/27
Doc/Data				<del>discrepancy</del>		Should be installed at			
Equip/Tooling				<del>angle of 15° to</del>		angled to match orientation			
Handling/Pre				<del>discrepancy was not in line</del>		of D4000-045.			
Material				<del>with</del>		Make ANGLED D4000-1			
Operator				When installing		using 6061-T6 ROUND BAR			
Offset/Setup				D4000-045 employee had		BIN 10/16/94			
Process				to apply force on D4000-1		2.8" slope with profile to			
Supplier				and caused it to separate		match D4000-1.			
Training				from the tank		INSTALL WITH PRUSEAL 850			
Transport					AND M520426914 RIVETS				
Unapproved									

## FAULT CATEGORY

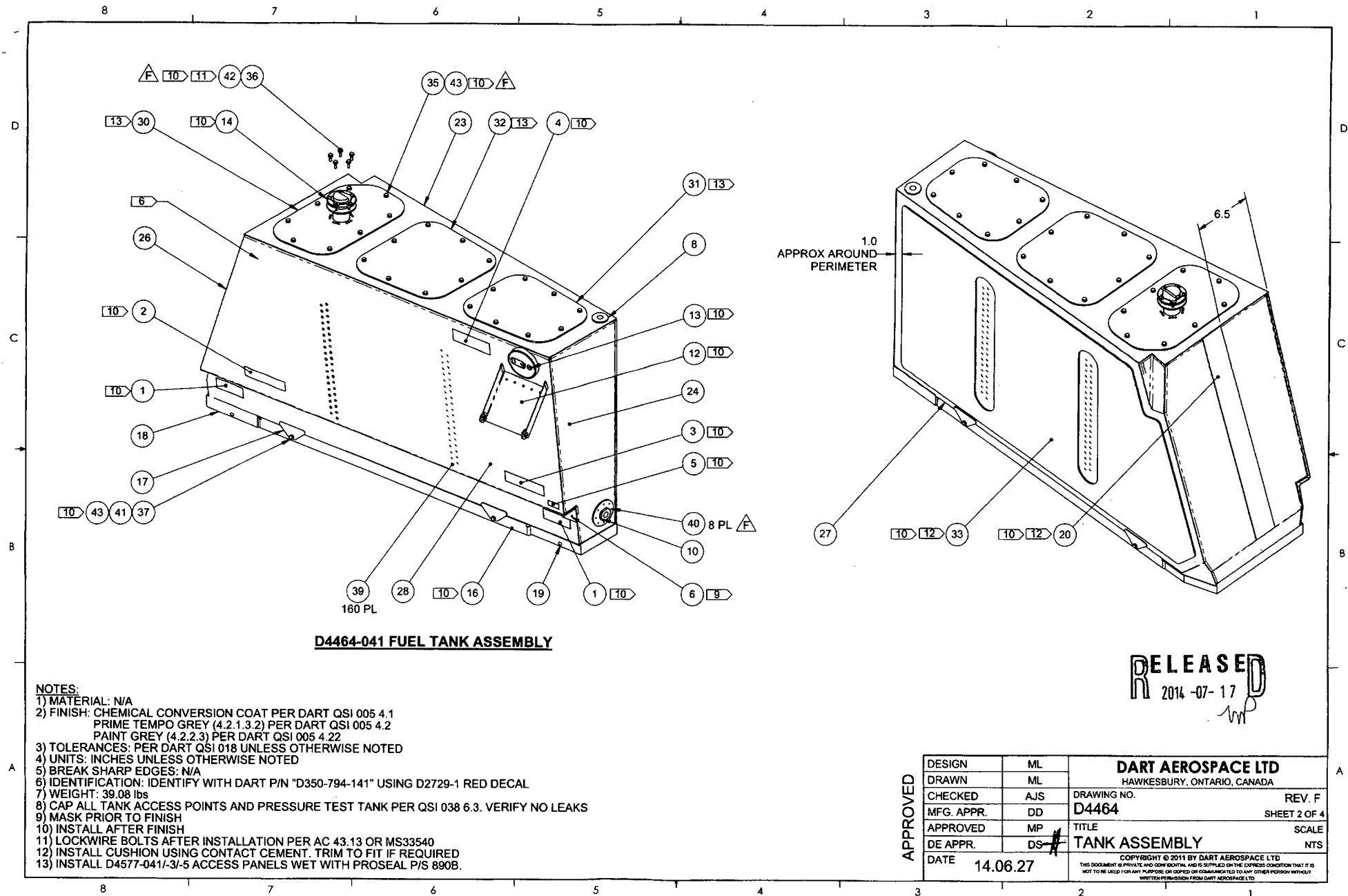
Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	<input type="checkbox"/> Set-up
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
			<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

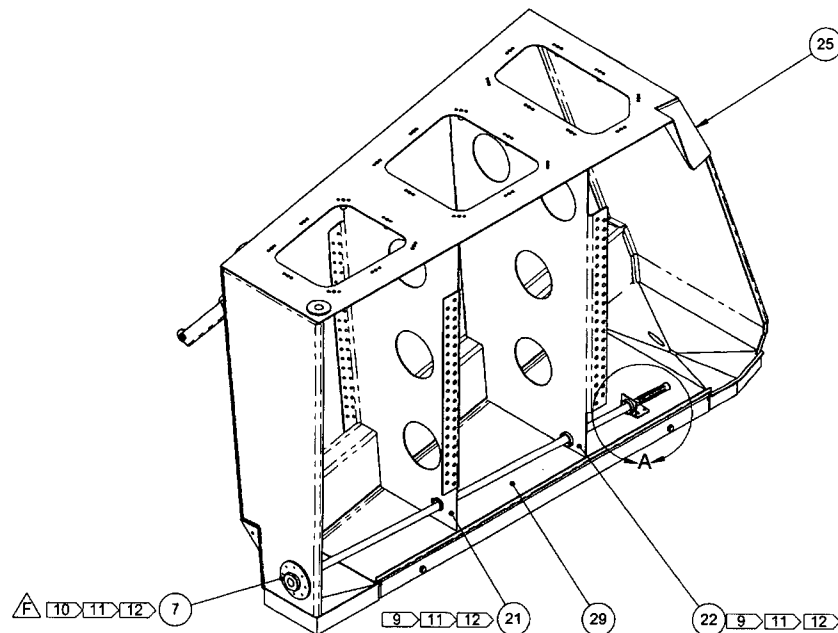
ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4464-041	FUEL TANK ASSEMBLY
1	2	D3997-5	PLACARD (AUX FUEL DRAIN)
2	1	D3997-11	PLACARD (LOADING)
3	1	D3997-17	PLACARD (STOWAGE)
4	1	D3997-29	PLACARD (WARNING)
5	1	D3997-43	PLACARD (EARTH)
6	1	D3999-7	CORNER
7	1	D4000-1	FUEL SUPPLY FITTING
8	1	D4000-5	FUEL TANK VENT FITTING
9	3	D4000-9	GROMMET
10	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
11	1	D4008-11	TANK HINGE HALF
12	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
13	1	D4023-3	FUEL CAP AND FLANGE
14	1	D4025-5	FUEL SENDER
15	3	D4057-1	RETAINER
16	1	D4062-041	TANK SUPPORT
17	4	D4124-1	TAB
18	1	D4125-1	FWD SEDIMENT BOWL
19	1	D4125-3	AFT SEDIMENT BOWL
20	2	D4404-5	CUSHION, FWD
21	1	D4462-1	BAFFLE
22	1	D4462-3	BAFFLE
23	1	D4463-041	TOP TANK ASSEMBLY
24	1	D4463-3	TANK AFT END
25	1	D4463-5	TANK UPPER CUT OUT
26	1	D4463-7	TANK FORWARD END
27	1	D4463-9	TANK BACK
28	1	D4463-11	TANK FRONT
29	1	D4463-13	TANK BOTTOM
30	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
31	1	D4577-1	REAR ACCESS PANEL
32	1	D4577-3	MIDDLE ACCESS PANEL
33	1	D4968-1	CUSHION, SIDE
34	1	D4975-1	ANGLE BRACKET
35	24	AN3-5A	BOLT
36	5	AN3H5A	BOLT
37	4	AN3-6A	BOLT
38	4	MS20426AD4-4	RIVET, CSK
39	165	MS20470AD4-4	RIVET, PANHEAD
40	8	MS20470AD4-6	RIVET, PANHEAD
41	4	MS21042L3	NUT
42	5	NAS1149D0332J	WASHER
43	32	NAS1149D0363J	WASHER

RELEASED  
2014-07-17

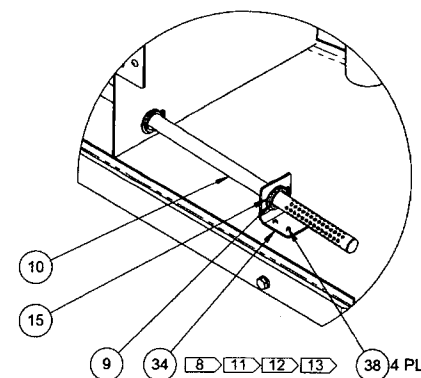
F	AN3-5A WAS AN3C4A QTY. 24 (ZN D8-2) AN3H5A WAS AN3-5A QTY. 5 (ZN D7-2) MS20470AD4-6 WAS MS20426AD4-6 QTY. 8 (ZN B5-2) D4000-1 IS NO LONGER INSTALLED WITH COUNTERSUNK RIVETS UPDATE NOTE 10 ON SHEET 3	ML	14.06.27
E	UPDATED -041 WITH RE-DESIGNED D4463-3/-9/-11 AND D4462-1/-3. D4968-1 REPLACES D4404-5 ON TANK SIDE (ZN C3-2) REF NCR 13-3100 AN3-6A REPLACES MS35206-286 (ZN B8-2) NAS1149D0332J REPLACES 5 X NAS1149D0363J (ZN D7-2) REF PAR 12-217 D4975-1 REPLACES D3999-9 (ZN C3-2) REMOVED TAB D3999-11 AND MOVED D3997-43 PLACARD (ZN B6-5) UPDATED BILL OF MATERIALS REVISED ALL NOTES REMOVED SHEET 5	ML	14.05.13
D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS, ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS. REMOVED D4463-13. ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. F
MFG. APPR.	DD	D4464	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	14.06.27	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED





**D4464-041 FUEL TANK ASSEMBLY**  
D4463-9 TANK BACK REMOVED  
TO SHOW INTERIOR DETAIL



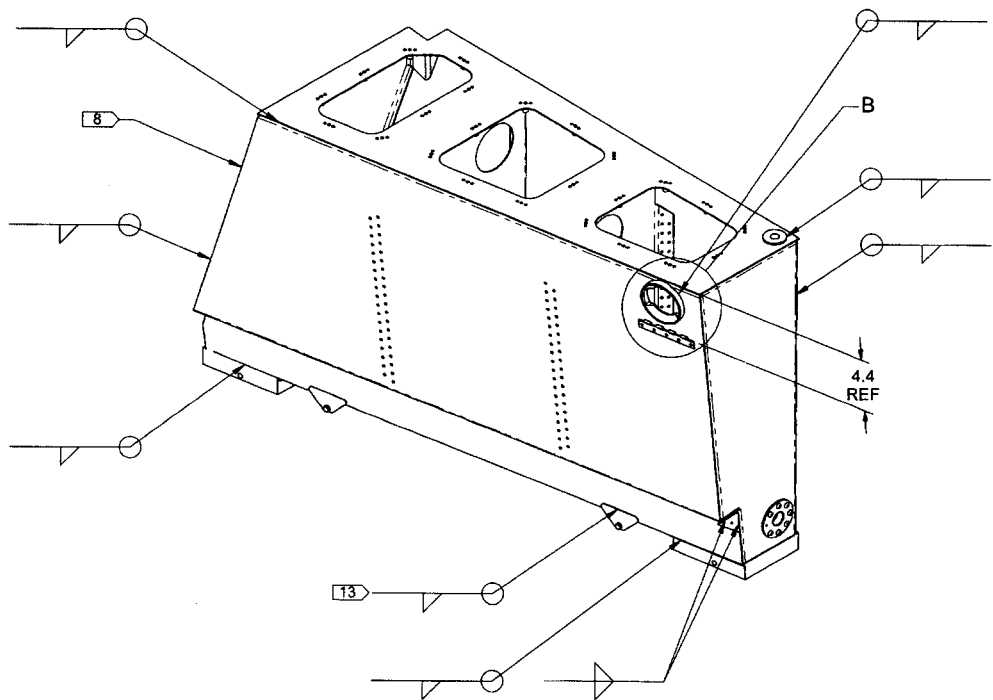
**DETAIL A**  
ROTATED FOR CLARITY  
SCALE 2X

**NOTES:**

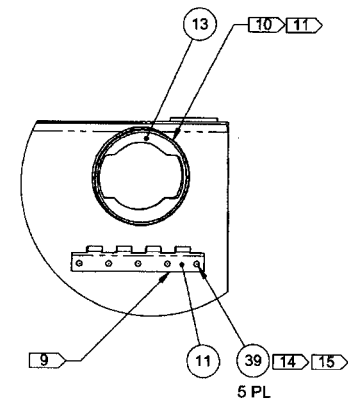
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) COAT FAYING SURFACES OF D4975-1 ANGLE BRACKET AND D4463-13 TANK BOTTOM WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-4 RIVETS
- 9) COAT FAYING SURFACES OF D4462-1/-3 BAFFLES AND D4463-9/-11 TANK FRONT/BACK WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 10) COAT FAYING SURFACES OF D4000-1 FUEL SUPPLY FITTING AND D4463-3 TANK AFT END WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-6 RIVETS
- 11) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF D4975-1 ANGLE BRACKET, D4462-1/-3 BAFFLES AND D4000-1 FUEL SUPPLY FITTING WITH PROSEAL P/S 890B
- 12) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B
- 13) TRANSFER DRILL  $\phi 0.128$  HOLES FROM D4975-1 ANGLE BRACKET INTO D4463-13 TANK BOTTOM AND COUNTERSINK HOLES  $\phi 0.225 \times 100^\circ$  FROM THE OUTSIDE OF THE TANK

**RELEASED**  
2014-07-17

APPROVED	DESIGN	ML	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	ML		
	CHECKED	AJS	DRAWING NO.	REV. F
	MFG. APPR.	DD	<b>D4464</b>	SHEET 3 OF 4
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	<b>TANK ASSEMBLY</b>	NTS
DATE		14.06.27	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D4464-041 FUEL TANK ASSEMBLY**  
WELDING AND RIVETING DETAIL



**DETAIL B**  
ROTATED FOR CLARITY  
SCALE 2X

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 9) CENTER HINGE BELOW FUEL CAP FLANGE
- 10) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 11) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 12) WELD PER DART QSI 004
- 13) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING  
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING
- 14) COAT FAYING SURFACES OF D4008-11 TANK HINGE HALF AND D4463-11 TANK FRONT WITH PROSEAL P/S 890B  
AND WET INSTALL MS20470AD4-4 RIVETS
- 15) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B

**RELEASED**  
2014-07-17

APPROVED

DESIGN	ML	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. F
MFG. APPR.	DD	<b>D4464</b>	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	<b>TANK ASSEMBLY</b>	NTS
DATE	14.06.27	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	